

Work Order ID 122967

Tuesday, July 29, 2014 2:27:07 PM

122967

Page 1

Item ID: D3901-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 7/25/14 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 7/29/14 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: wm Date: 7/30/14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3901 | E | | | | | | | | |

100 0.00
100
 Cold Saw Memo 0.00 cmk 14/08/02 16 10
 Hyd Mech Cut blanks at 55.1875"

110 0.00
110
 HAAS 1 Memo 0.00 cmk 14/08/03 16 0
 HAAS CNC vertical machine #1
 1-Mill as per folio FB090 & dwg D3901,
 FOLIO REV: AA
 DWG REV: E
 2-Deburr as required

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | |
|--|--|---|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> |
|--|--|---|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | 16 | 6 | | |
| Quality Control | ***EXTRA MATERIAL WILL BE CUT ON ASSEMBLY*** | | | | | | | | |
| 130 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | 16 | 0 | | |
| Quality Control | ***EXTRA MATERIAL WILL BE CUT ON ASSEMBLY*** | | | | | | | | |
| 140 | Identify as per dwg & Stock Location: <u>WAC01</u> | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | 16 | | | |
| Packaging | | | | | | | | | 14-08-12 MAL |

DAS
44 14/08/04
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
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| Training | | | | | | | | | |
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Page 3

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|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

ML5 14-08-12
MLP 14-08-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Offset/Setup | | | | | | | | | |
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| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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|--|--|---|--|

Picklist Print

Tuesday, July 29, 2014 2:27:06 PM

Page 1

Work Order ID: 122967

122967

Parent Item: D3901-1

D3901-1

Parent Item Name: Bar

Start Date: 7/25/14

Required Date: 7/29/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC
Now on cnc JFS 12/02/13 verified by:JLM

IPP RevB:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304B0.250x0.500 | | Purchased | | | | 100 | f | 661.4532 | 4.513 | 38.00421 | | | |

M304B0 250x0 500

**

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT049

661.4532

→ m127209

69

M128085

8.4532

m129366

584

39+39 *OK 14/08/02*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

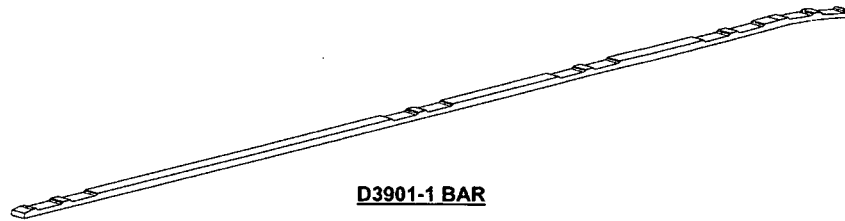
FAULT CATEGORY

| | | | |
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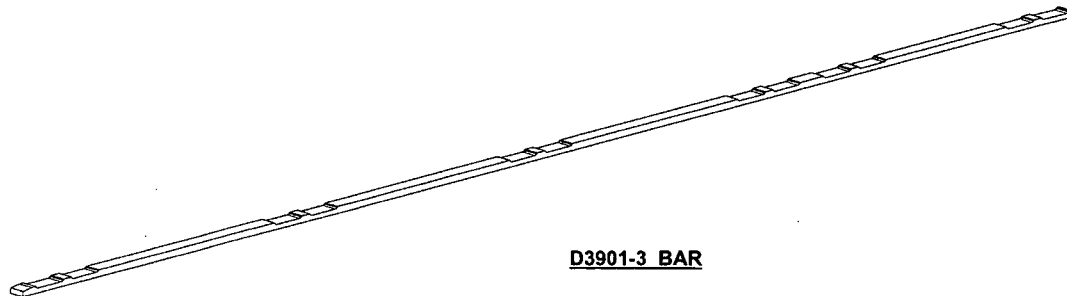
8 7 6 5 4 3 2 1

D
C
B
A

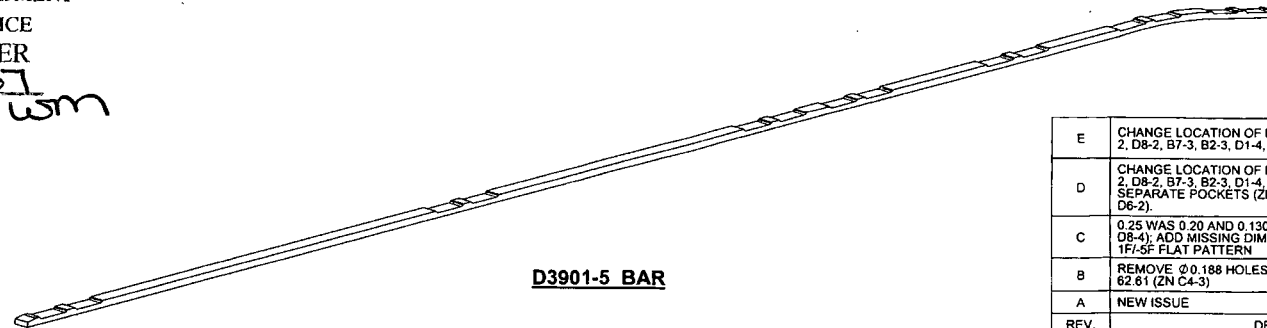
D
C
B
A



D3901-1 BAR



D3901-3 BAR



D3901-5 BAR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 1552167
7/30/14 WSM

RELEASED
2012-09-04
WP

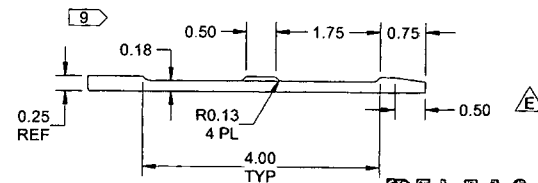
| | | | |
|------------|--|--|--------------|
| E | CHANGE LOCATION OF END POCKETS ON -1/3/5 (ZN B1-2, D8-2, B7-3, B2-3, D1-4, D7-4). | DC | 12.08.23 |
| D | CHANGE LOCATION OF END POCKETS ON -1/3/5 (ZN D1-2, D8-2, B7-3, B2-3, D1-4, D8-4). SPLIT POCKETS INTO TWO SEPARATE POCKETS (ZN A2-2). ADD POCKET TO -1 (ZN D6-2). | DC | 12.08.21 |
| C | 0.25 WAS 0.20 AND 0.130 WAS 0.080 (ZN B2-2, B1-2, B1-3, D8-4); ADD MISSING DIMENSIONS (ZN C5-3); ADD D3901-1F-SF FLAT PATTERN | RF | 12.01.24 |
| B | REMOVE Ø 0.188 HOLES FROM D3901-1/3/5; 62.12 WAS 62.61 (ZN C4-3) | RF | 09.06.30 |
| A | NEW ISSUE | RF | 09.03.30 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE USA, INC. | |
| DRAWN | DC | KENT, WA | |
| CHECKED | DE | DRAWING NO. | REV. E |
| MFG. APPR. | DE | D3901 | SHEET 1 OF 4 |
| APPROVED | DE | TITLE | SCALE |
| DE APPR. | DE | BAR | NTS |
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D3901-1F BAR FLAT PATTERN

D3901-1 BAR (MAKE FROM D3901-1F)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 THICK X 0.500 WIDTH
PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X0.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.78 lbs
- 8) FORM TO FIT WEARPLATE
- 9) ANGLE TO BE DETERMINED BY AVAILABLE TOOLING

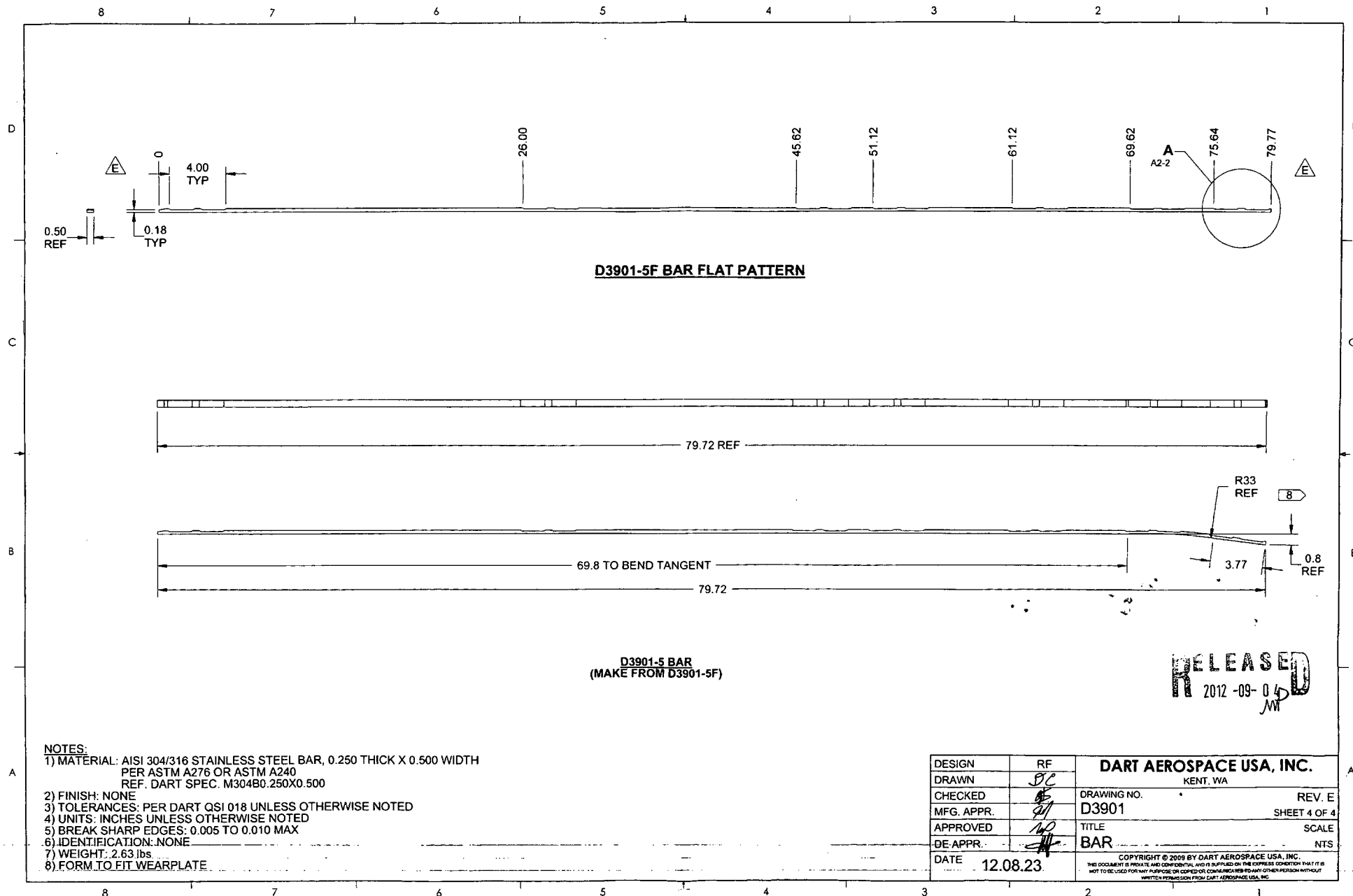


DETAIL A
TYP

D1-2
B2-3
D1-4

RELEASED
2012-09-04

| | | | |
|------------|----------|---|--------------|
| DESIGN | RF | DART AEROSPACE USA, INC. | |
| DRAWN | DL | KENT, WA | |
| CHECKED | DL | DRAWING NO. | REV. E |
| MFG. APPR. | DL | D3901 | SHEET 2 OF 4 |
| APPROVED | DL | TITLE | SCALE |
| DE APPR. | DL | BAR | NTS |
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NOTES:

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PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X0.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.63 lbs
- 8) FORM TO FIT WEARPLATE

| DESIGN | RF | DART AEROSPACE USA, INC. | |
|------------|----------|---|--------------|
| DRAWN | DC | KENT, WA | |
| CHECKED | AS | DRAWING NO. | REV. E |
| MFG. APPR. | SA | D3901 | SHEET 4 OF 4 |
| APPROVED | MD | TITLE | SCALE |
| DE APPR. | SA | BAR | NTS |
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